

Date: Thursday, 29/01/2009 3:20:16 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : NUT PLATE ASSEMBLY
<b>Job Number</b> : 45369	
<b>Estimate Number</b> : 11053	
<b>P.O. Number</b> :	<b>Part Number</b> : D2873043
<b>This Issue</b> : 29/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2873 REVA
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 43669	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 05/02/2009 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09.01.29</u>	
<b>Comment</b> : Est A05.09.13 New issue KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6B0375X01000	6061T6 BAR .375 x 1.00
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**Comment:** Qty.: 0.3237 f(s)/Unit Total: 6.4743 f(s)  
 6061T6 BAR  
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)  
 (M6061T6B0.375x01.000)  
 Identify for D2873-3  
 Batch: M11D001

JUL 09/01/31

(20)

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW  
 Cut blanks: 1.000" x 0.375" x 3.700" long

JUL 09/01/31

(20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA and Dwg D2873  
 Identify as D2873-3 Dwg Rev A Folio Rev A

PTC

(21)

MME 09/02/01

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE


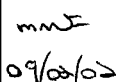
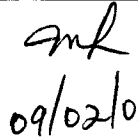
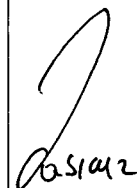
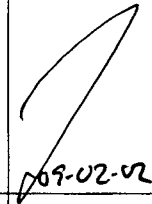
MME 09/02/01

(21)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2873-043 PAR #: NA Fault Category: Real Machined Parts NCR: Yes No DQA: D Date: 09/02/11  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: D Date: 09/02/11

NCR:45369		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/02	3.0	piece jump out of jig. <del>was</del> Vise was too tight, i tool popped out the part on the final pass. R.C. Process.	 09/02/02	Part has very minor damage on the side. Bolt smooth, deviation is 0.004" at the deepest spot.	 09/02/02	 09/02/02	 09/02/02	 09-02-02

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 45369

Part Number: D2873043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*mk 09/02/02*

(21)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

*Ep 09/02/03* (21)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 02/02/03* (20)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FL 09/02/05*

(21)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

*09-02-06* (20)

10.0

MS20426AD46

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 120.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

6

MS20426AD4-6

Rivet

*h105144*

*Pc*

11.0

MS21075L5

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

3

MS21075L5

Nut Plate

*18136*

*Pc 4/2/6* (21)

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## Process Sheet

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Job Number: 45369

Part Number: D2873043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ml 09/02/10

(21)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF  
09-02-10

Job Completion



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 45389
<b>Description:</b> Radius Block		<b>Part Number:</b> D2873-3
<b>Inspection Dwg:</b> D2873	<b>Rev:</b> A	<b>Page 1 of 1</b>

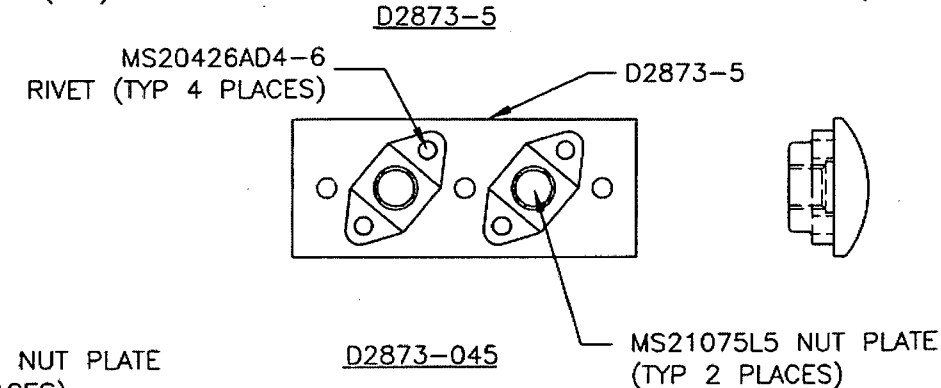
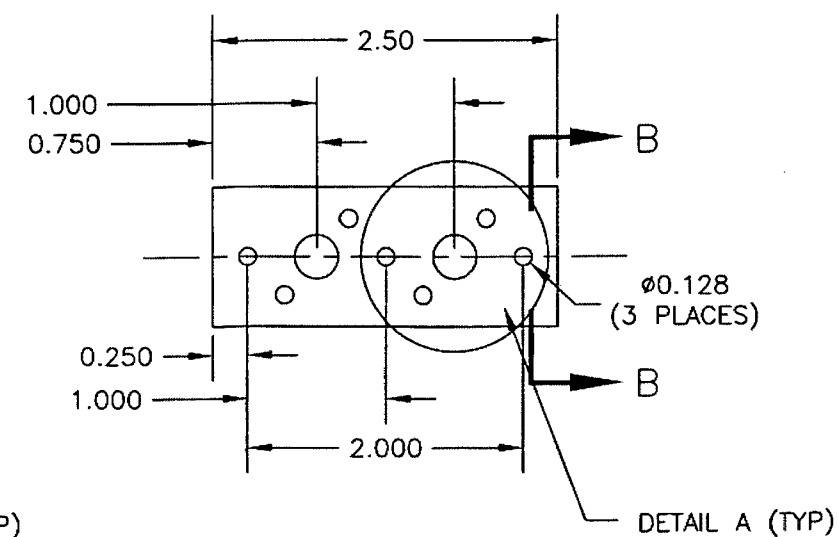
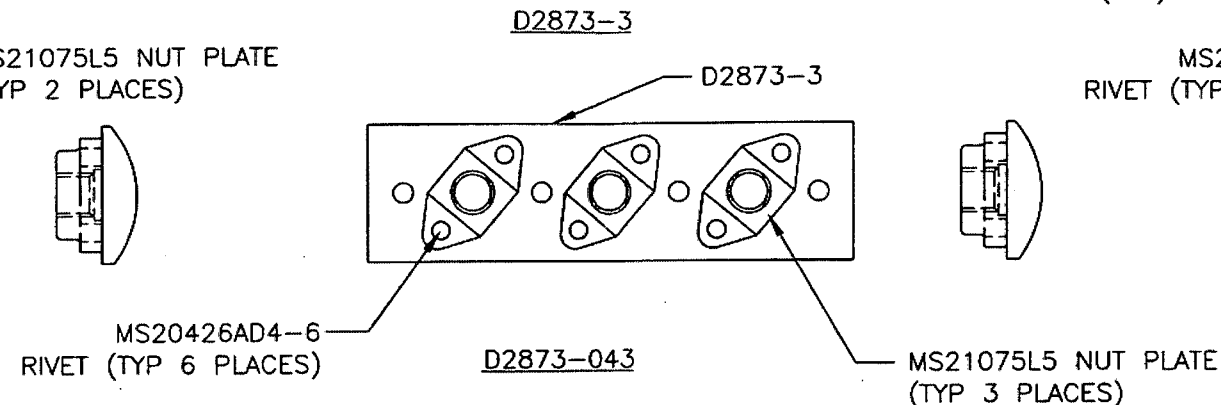
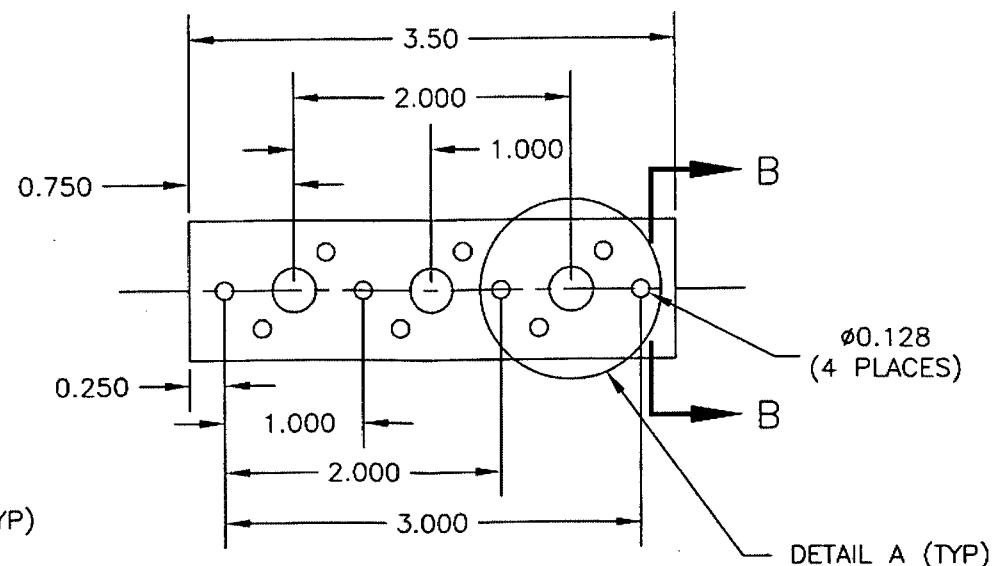
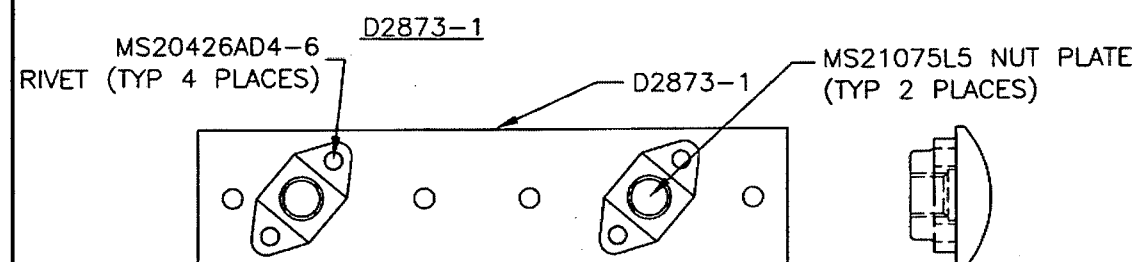
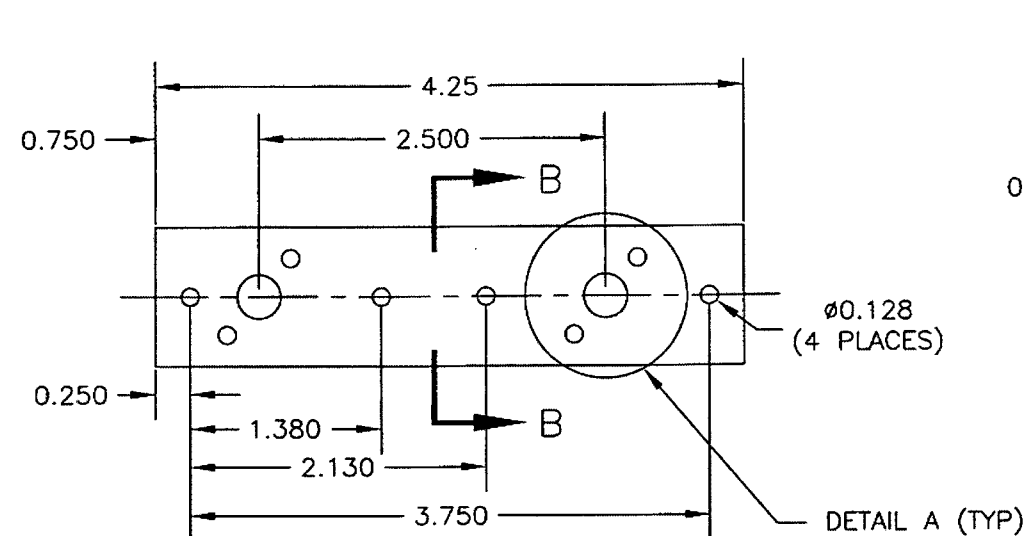
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50	✓			
2.000	+/-0.010	1.998	✓			
0.750	+/-0.010	.749	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	Ø .130	✓			
0.359	+/-0.010	.359	✓			
Ø0.316	+0.006/-0.001	Ø .317	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.250	✓			
0.061	+/-0.010	.061	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø .230 x .125	✓			

<b>Measured by:</b> mmk	<b>Audited by:</b> gmk	<b>Prototype Approval:</b> N/A
<b>Date:</b> 09/02/01	<b>Date:</b> 09/02/02	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	[Signature]



#### D2873-1/-3/-5 RADIUS BLOCK

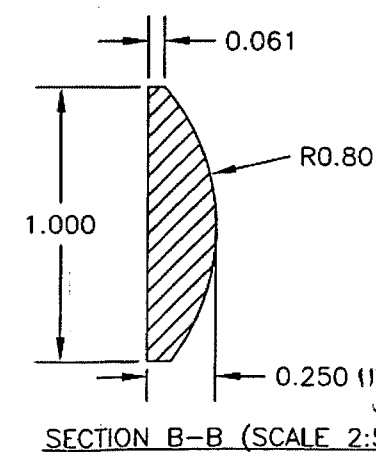
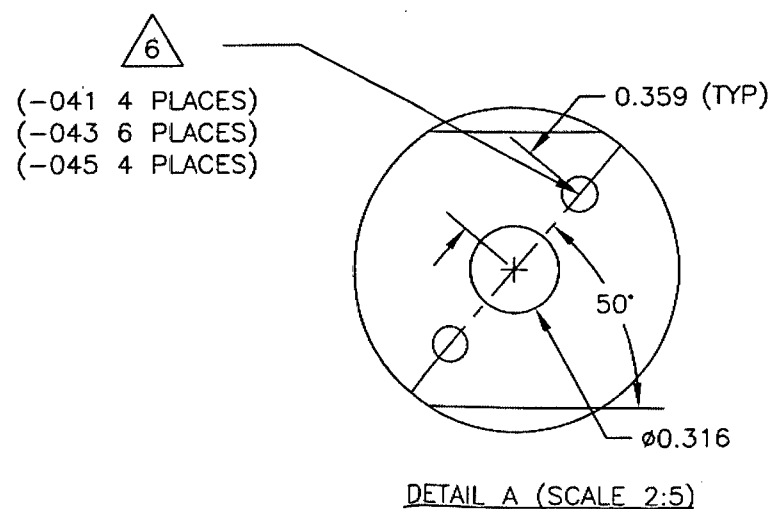
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

#### D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED  
 SHOP COPY  
 RETURN TO  
 DART AEROSPACE LTD  
 05.07.26  
 WORK ORDER  
 45369

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873 REV. A SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:5